



XT925 Assembly Manual

Revision: 1.1

Revision Date: 10/05/2012



DOCUMENT AMENDMENT HISTORY

Rev	Date	Details
0.1	08/22/2012	Initial draft release. Note that service specific fixtures are not illustrated. Illustrations to be updated on next release
1.0	09/27/2012	Released. Service fixtures are not all illustrated
1.1	10/05/2012	Updated Acoustic gasket illustrations

Note: Part numbers listed in this document are for operations reference only. The product SBOM takes precedence over any differences.



Tools and Test Equipment

Motorola Part Number	Description	Application
	Tweezers, plastic	Used during assembly/ disassembly
	Antistatic Mat kit	Provides protection from damage to device caused by electrostatic discharge (ESD)
----	Torx Plus bit 5IP. Torque setting is 1.1 in/lbs @500RPM	Rear Housing screws
----	Torx Plus bit 5IP. Torque setting is 1.0 in/lbs @500RPM	HSJ bracket and imager bracket screws
----	Torx Plus bit 5IP. Torque setting is 0.8 in/lbs @500RPM	Earpiece Speaker bracket screws
----	Torx Plus bit 5IP. Torque setting is 1.0 in/lbs @500RPM	PCB screws
----	Torx Plus bit 5IP. Torque setting is 0.75 in/lbs @350RPM	Side key flex screws
4-00-C3-10000 (AMS) ¹	Battery Adhesive Alignment Tool	
4-00-C4-10000 (AMS) ¹	Battery to Rear Housing Press	
4-00-C5-10000 (AMS) ¹	Acoustic Gasket Alignment	
4-00-C6-10000 (AMS) ¹	Camera Lens Press	
4-00-C7-10000 (AMS) ¹	Heat Spreader to PCB Alignment	
4-00-C8-10000 (AMS) ¹	Speaker to Rear Housing Press	
4-00-C9-10000 (AMS) ¹	Display / ITO Flex Press	
0-00-00-30005 (AMS) ¹	Disassembly tool, plastic with flat and pointed ends (manual opening tool)	Used during assembly/disassembly

1. To order tooling please visit the AMS online-shop: <http://www.online-shop.ams-fl.com>



SAFETY CRITICAL

Use of Electrostatic Discharge (ESD) prevention equipment where required to avoid damage to susceptible battery protection circuitry during handling and repair processes.



TORX Screws (T3, T5, etc.)



TORX PLUS Screws (3IP, 5IP, etc.)



Attention should be paid to the distinction of TORX® and TORX PLUS®: Do not interchange screws and tools.



XT925

Assembly

Poly Speaker

Global Doc #

Regional Doc #

Revision

1.1

Date

10/05/12

Page:

4

1. Remove adhesive liner from the Poly Speaker and apply to the Rear Housing



2. Bend the connector perpendicular to the speaker so it does not get damaged during seating



3. Note the rear housing features which align the speaker in the housing pocket.



Symbols



Attention



Operation



Verification

Material List

Description / Part #	Qty
Rear Housing Sub-Assy	1
Poly Speaker	1

Tools/Equipment

Description	Parameters



XT925

Assembly

Poly Speaker

Global Doc #

Regional Doc #

Revision

1.1

Date

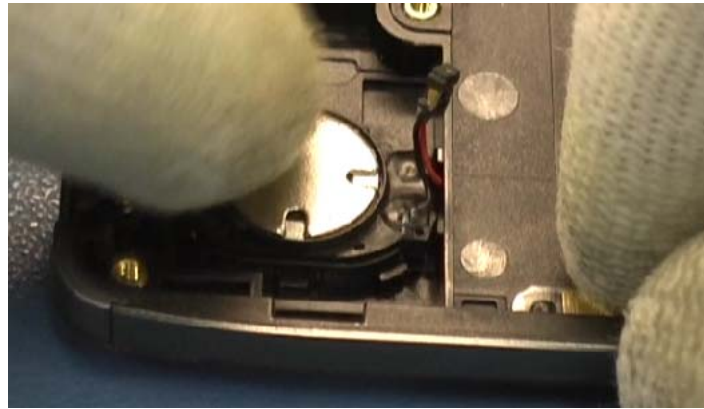
10/05/12

Page:
5

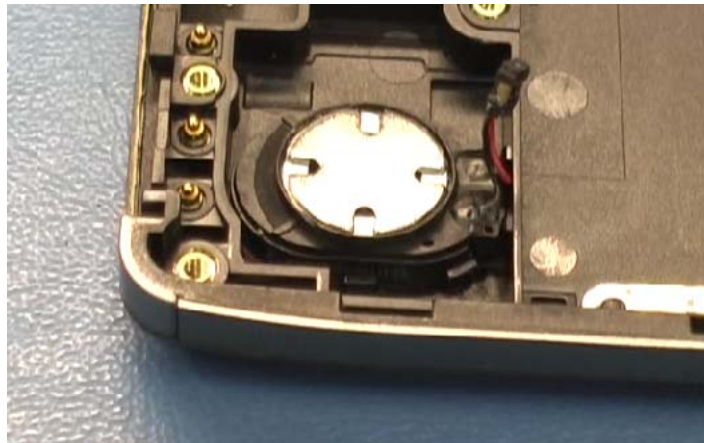
1. Place speaker in rear housing pocket



2. Press to insure speaker is properly aligned and seated in housing.



3. Place the Rear Housing sub-assembly in the speaker to rear housing press and activate for 5s



Symbols



Attention



Operation



Verification

Material List

Description / Part #	Qty
Rear Housing Sub-Assy	1
Poly Speaker	1

Tools/Equipment

Description	Parameters
Speaker to Rear Housing press	5s



XT925

Assembly

Side Key Assy

Global Doc #

Regional Doc #

Revision

1.1

Date

10/05/12

Page:

6

- 1. Using the alignment pins, lay the side key bracket on the side key alignment fixture.
- 2. Remove the liner from the side key flex.
- 3. Carefully align the side key flex to the bracket using the three alignment holes.
- 4. Using the alignment pins, place the poron pad assembly over the side key flex.
- 5. Remove the liner from the poron pads and verify that the pads are properly seated



Symbols



Attention



Operation



Verification

Material List

Description / Part #	Qty
Sidekey Flex	1

Tools/Equipment

Description	Parameters
Side Key Flex alignment fixture	



XT925

Assembly

Side Key Assy

Global Doc #

Regional Doc #

Revision

1.1

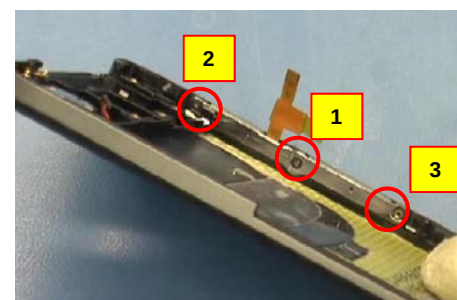
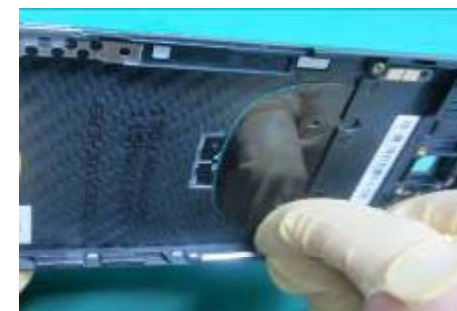
Date

10/05/12

Page:

7

1. Assembly the power button in the housing pocket.
2. Assemble the power key in the housing pocket
3. Assemble the side key flex assembly by aligning to the 3 screws bosses
4. Using a IP3 driver, assembly 3 screws in the order illustrated



Symbols



Attention Operation Verification

Material List

Description / Part #	Qty
Sidekey Flex	1
Rear Housing assembly	1

Tools/Equipment

Description	Parameters
3IP Driver	0.75 $\pm$ 0.1in.lb 350 $\pm$ 10 RPM



XT925

Assembly

Headset Jack Assy

Global Doc #

Regional Doc #

Revision

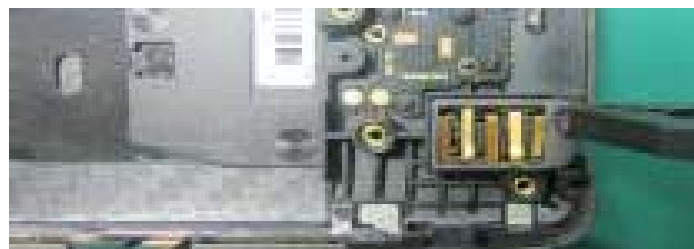
1.1

Date

10/05/12

Page:
8

- 1. By aligning against the edge of the bottom wall of the headset jack pocket, place the headset jack adhesive strip in the pocket.
- 2. Assemble the headset jack in the pocket of the housing.
- ▲ 3. DO NOT press directly on contacts
- 4. Press down on headset jack for good adhesion.
- 5. Carefully place seal over headset jack
- 6. Inspect that there is no damage or wrinkles on seal.



Symbols



Attention



Operation



Verification

Material List

Description / Part #	Qty
Headset Jack Adhesive	1
Headset Jack	1
Headset Jack seal	1

Tools/Equipment

Description	Parameters
Plastic Tweezers	

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Template Rev C



XT925

Assembly

Camera Lens

Global Doc #

Regional Doc #

Revision

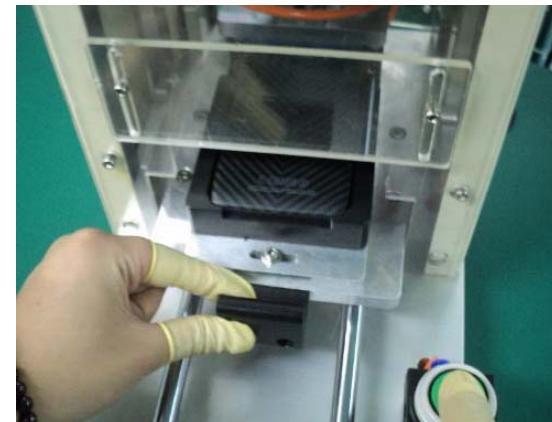
1.1

Date

10/05/12

Page:
9

- 1. Remove Camera lens from adhesive liner
- 2. Align the camera lens in the housing pocket.
- ▲ 3. Avoid direct contact to inside lens windows
- 4. Place housing assembly in Camera lens fixture and press for 5 seconds.



Symbols



Attention



Operation



Verification

Material List

Description / Part #	Qty
Rear Housing Assembly	1
Camera Lens	1

Tools/Equipment

Description	Parameters
Plastic Tweezers	
Camera Lens Press	5 s



XT925

Assembly

Proximity grommet

Global Doc #

Regional Doc #

Revision

1.1

Date

10/05/12

Page:
10

1. Align proximity grommet over emitter and receiver sensors of the audio flex assembly.



2. Inspect that grommet is fully seated on PCB.



Symbols



Attention



Operation



Verification

Material List

Description / Part #	Qty
Audio flex assy	1
Proximity grommet	1

Tools/Equipment

Description	Parameters



XT925

Assembly

Audio Flex assy

Global Doc #

Regional Doc #

Revision

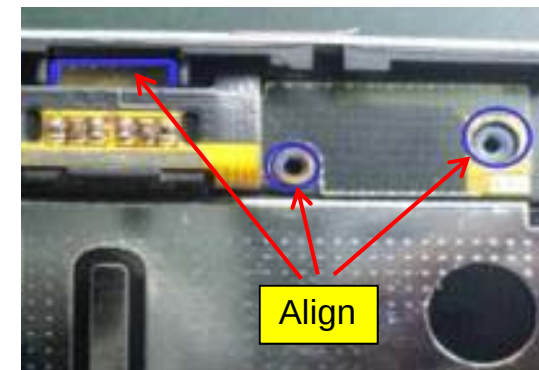
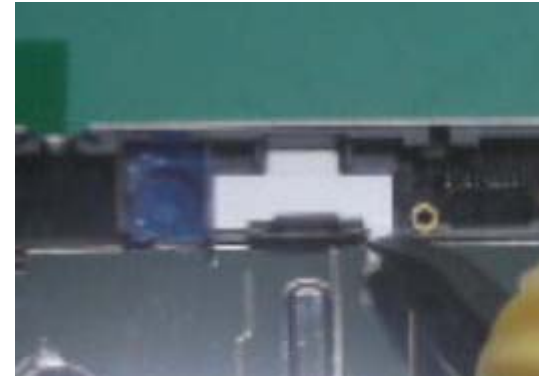
1.1

Date

10/05/12

Page:
11

- 1. Remove the audio flex liner from the housing. If reusing housing, insure new adhesive is placed.
- 2. Clean proximity pocket with air gun.
- 3. Verify that no foreign materials are on mesh
- 4. Place earpiece speaker in earpiece pocket. Use the screw busses and housing pocket for alignment



Symbols



Attention



Operation



Verification

Material List

Description / Part #	Qty
Audio flex assy	1
Front housing assy	1

Tools/Equipment

Description	Parameters



XT925

Assembly

Audio Flex assy

Global Doc #

Regional Doc #

Revision

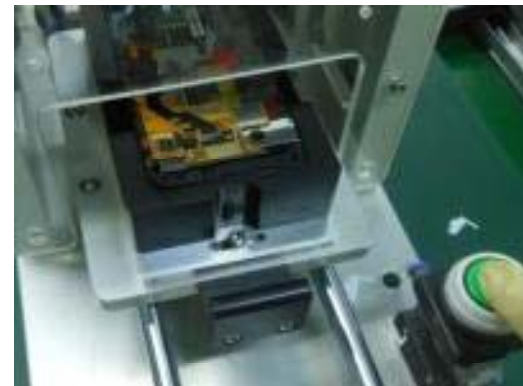
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Date

10/05/12

Page:
12

- 1. Remove the audio flex liner.
- 2. Adhere flex to front housing assembly by aligning to etched markings.
- 3. Place assembly in audio flex press fixture and press for 5 seconds



Symbols



Attention



Operation



Verification

Material List

Description / Part #	Qty
Audio flex assy	1
Front Housing Assy	1

Tools/Equipment

Description	Parameters
Audio flex press fixture	5s



XT925

Assembly

Camera Flex

Global Doc #

Regional Doc #

Revision

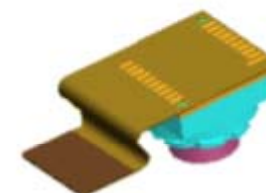
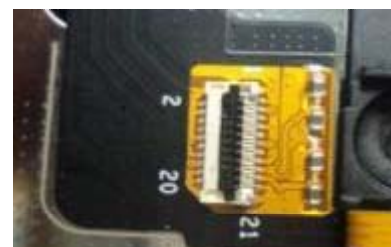
1.1

Date

10/05/12

Page:

1. Lift the ZIF door
2. Remove the camera lens liner and clean camera pocket with ionized air
3. Bend the flex in a "Z" form.
4. NOTE: Do not bend it from the tip of the pins
5. Insert the camera flex into the ZIF connector until the line marker is aligned with the connector
6. Close the ZIF door
7. Verify that the line marker is aligned with the connector
8. Place kapton tape over the ZIF connector



Symbols



Attention



Operation



Verification

Material List

Description / Part #	Qty
Camera flex assy	1
Front Housing Assy	1
Kapton tape	1

Tools/Equipment

Description	Parameters

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Template Rev C



XT925

Assembly

Flex Bracket assy

Global Doc #

Regional Doc #

Revision

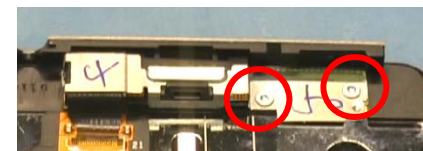
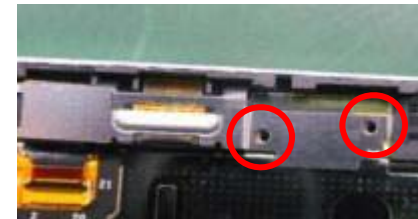
1.1

Date

10/05/12

Page:

- 1. Place Kapton tape over earpiece speaker
- 2. Align the bracket over the left hook
- 3. Align the bracket over the screw bosses
- 4. Latch the second hook
- 5. Inspect the left hook is not bent or misaligned
- 6. Attach two screws to bracket with torque setting of 0.8 in-lbs



Symbols



Attention Operation Verification

Material List

Description / Part #	Qty
Flex bracket	1
Front Housing Assy	1
Kapton tape	1

Tools/Equipment

Description	Parameters
IP3 torque driver	0.8 in-lbs @500 RPM



XT925

Assembly

Battery

Global Doc #

Regional Doc #

Revision

1.1

Date

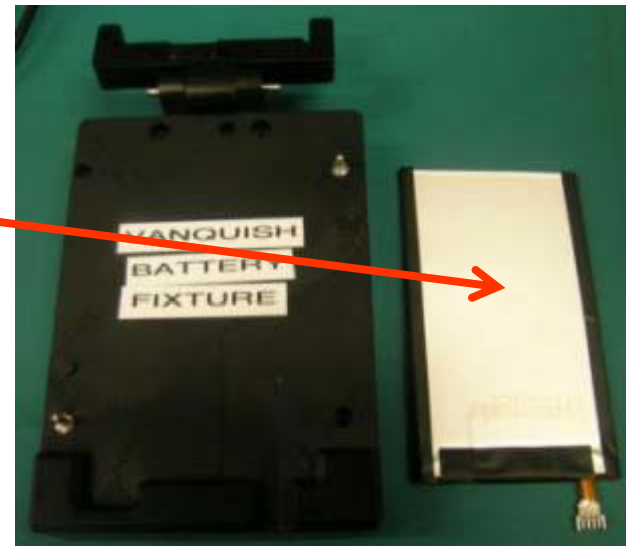
10/05/12

Page:
15This symbol indicates **SAFETY CRITICAL**.

Failure to adhere to **Safety Critical Note(s)** may increase risk of rupture, burning, or failure to function safely when used by the customer!

**SAFETY CRITICAL**

Ensure Battery and its insulation are not damaged (eg. scratched, dented, punctured) prior to and throughout assembly.



1. Place the battery into the battery adhesive alignment fixture, with the flex positioned in the lower right corner

**SAFETY CRITICAL**

Handle battery pack with care. If dropped to the floor, it may be internally damaged and must be scrapped.

**Symbols**

Attention



Operation



Verification

Material List

Description / Part #	Qty
Battery	1

Tools/Equipment

Description	Parameters
Battery Adhesive Alignment	NA



XT925

Assembly

Battery

Global Doc #

Regional Doc #

Revision

1.1

Date

10/05/12

Page:

16

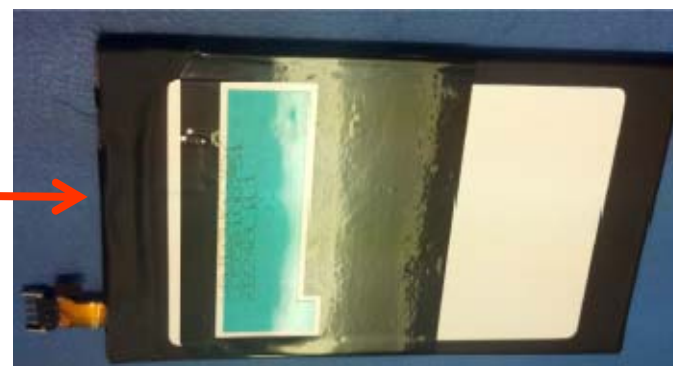
1. Place the Rear Battery Adhesive in battery adhesive alignment fixture.
2. Apply finger pressure to wet the adhesive to the battery.
3. Remove the clear adhesive carrier
4. Fold the Side Removal Tabs around the edge of the battery and apply pressure to wet the adhesive

**SAFETY CRITICAL**

Ensure Battery and its insulation are not damaged (eg. scratched, dented, punctured) prior to and throughout assembly.

**SAFETY CRITICAL**

Handle battery pack with care. If dropped to the floor, it may be internally damaged and must be scrapped.

**Symbols**

Attention



Operation



Verification

Material List

Description / Part #	Qty
Battery	1
Rear Adhesive	1

Tools/Equipment

Description	Parameters
Battery Adhesive Alignment	NA

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Template Rev C



XT925

Assembly

Battery

Global Doc #

Regional Doc #

Revision

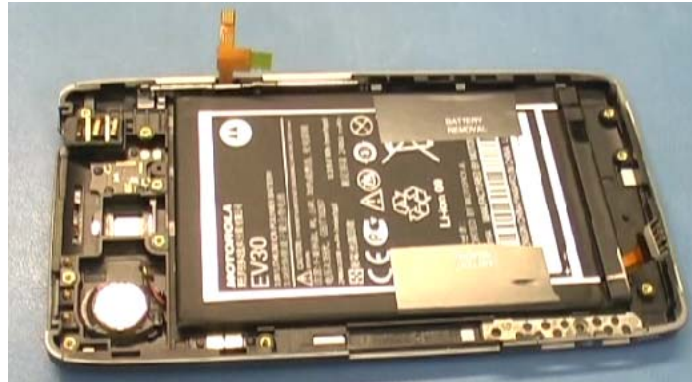
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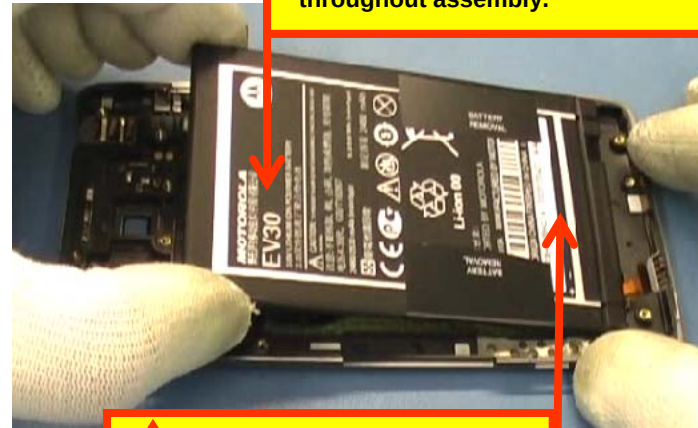
10/05/12

Page:
17

1. Remove the adhesive liner from the battery
2. Place the battery into the Rear Housing, aligning the bottom left corner first
3. Place the Rear Housing Sub-Assy in battery to rear housing press and activate press for 5s

**SAFETY CRITICAL**

Ensure Battery and its insulation are not damaged (eg. scratched, dented, punctured) prior to and throughout assembly.

**SAFETY CRITICAL**

Handle battery pack with care. If dropped to the floor, it may be internally damaged and must be scrapped.

Symbols

Attention



Operation



Verification

Material List

Description / Part #	Qty
Rear Housing Sub-Assy	1
Battery	1

Tools/Equipment

Description	Parameters
Battery to Rear housing Press	50N for 5s



XT925

Assembly

Labels

Global Doc #

Regional Doc #

Revision

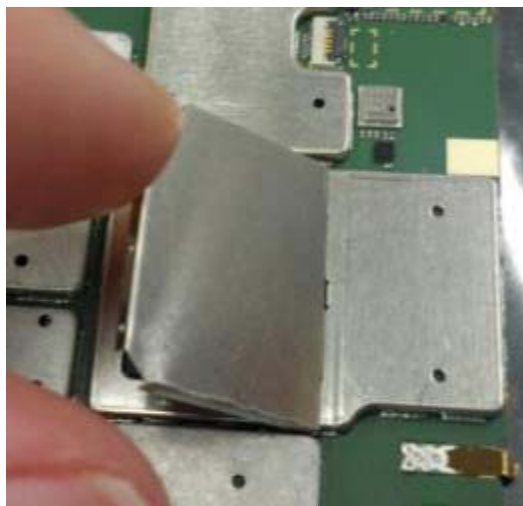
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Date

10/05/12

Page:
18

1. Blow off all connectors with Ionized Air Gun (Battery, ZIFs, Loudspeaker, Card Readers, uUSB, and HDMI)
2. Place Water Detect Labels in highlighted regions
3. Assemble AP Cap Shield by toeing in along the edge and then snapping the Cap over the base shield



Symbols



Attention



Operation



Verification

Material List

Description / Part #	Qty
PCB	1
Water Detect Label	2
AP Cap Shield	1
QC Label	1
Description	Parameters
Ionized Air Gun	NA

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XT925

Assembly

Heat Spreader

Global Doc #

Regional Doc #

Revision

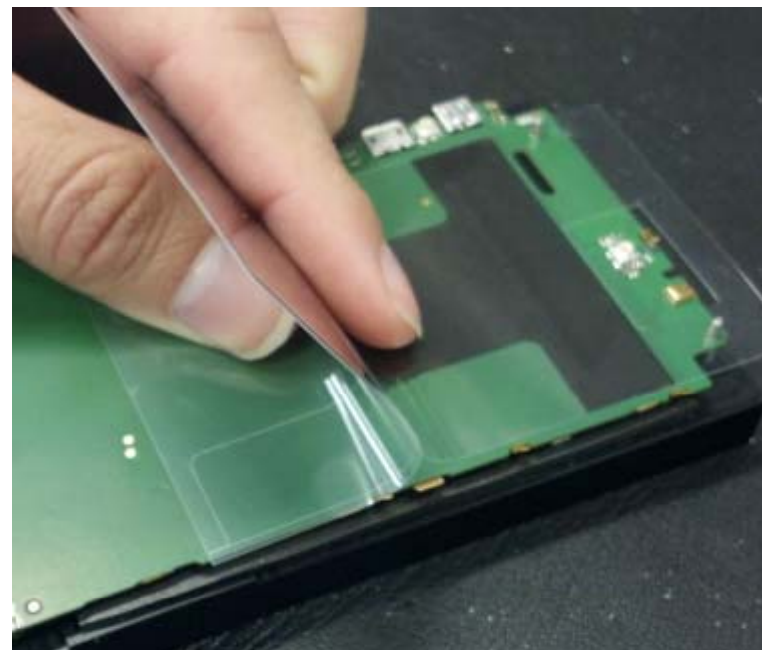
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Date

10/05/12

Page:
19

1. Place PCB onto heat spreader to PCB Alignment fixture
2. Peel off small liner from the Heat Spreader and align to the bottom 2 pins of the fixture



Symbols



Attention



Operation



Verification

Material List

Description / Part #	Qty
PCB	1
Heat Spreader	1

Tools/Equipment

Description	Parameters
Heat Spreader to PCB Alignment	NA

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XT925

Assembly

Heat Spreader

Global Doc #

Regional Doc #

Revision

1.1

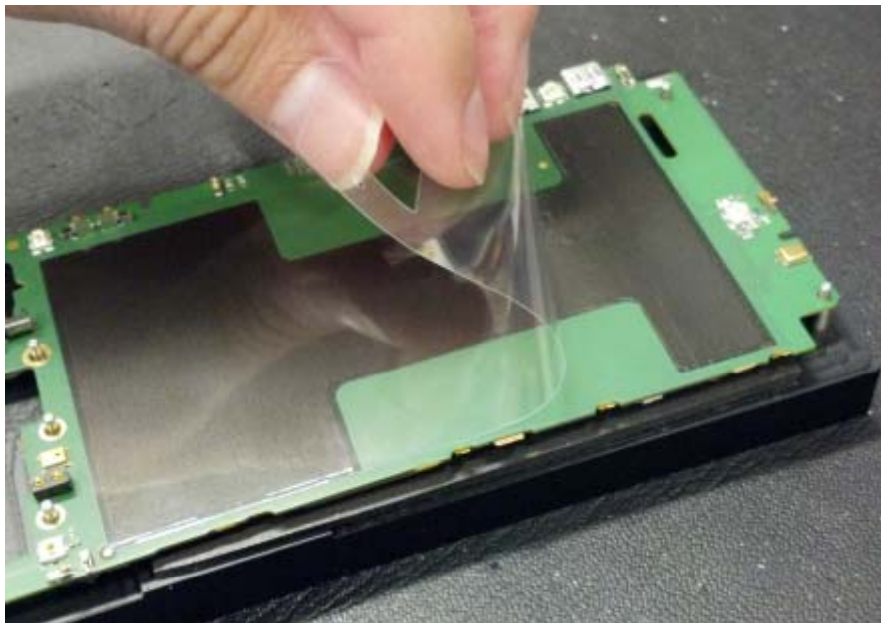
Date

10/05/12

Page:
20

-  1. Press the Heat Spreader onto the PCB by smoothing out the surface by hand
-  2. Peel away the carrier liner
-  3. Verify that there are NO creases or large bubbles in the heat spreader

(NOTE: Anything bigger than half a finger nail should be considered large)



Symbols



Attention



Operation



Verification

Material List

Description / Part #	Qty
PCB	1
Heat Spreader	1

Tools/Equipment

Description	Parameters
Heat Spreader to PCB Alignment	NA



XT925

Assembly

Pads and Tapes

Global Doc #

Regional Doc #

Revision

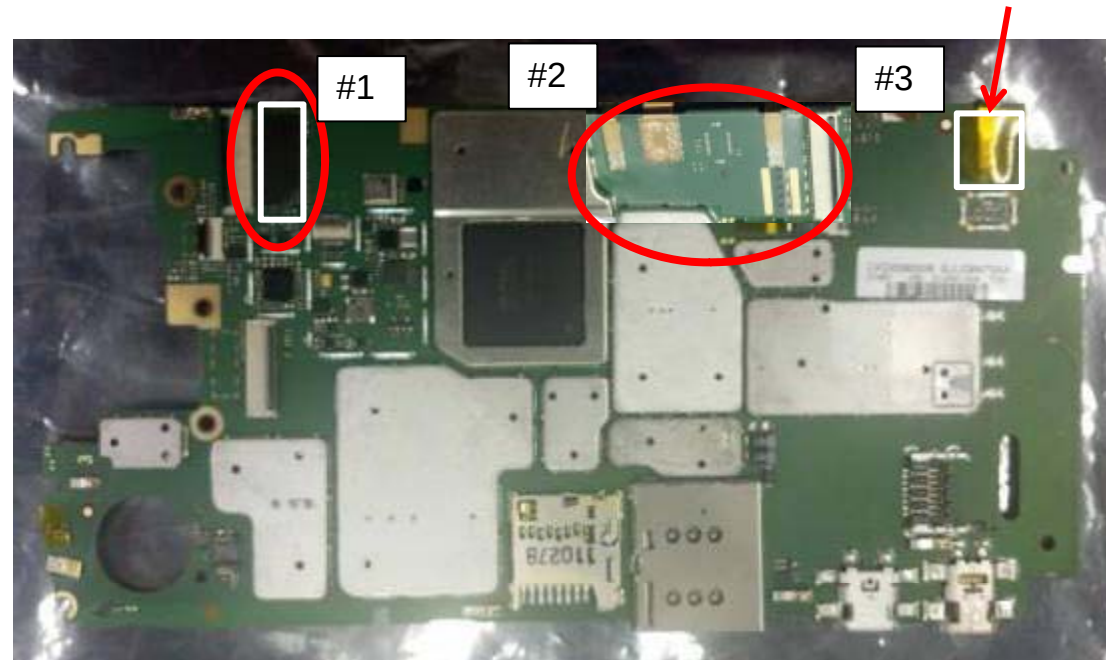
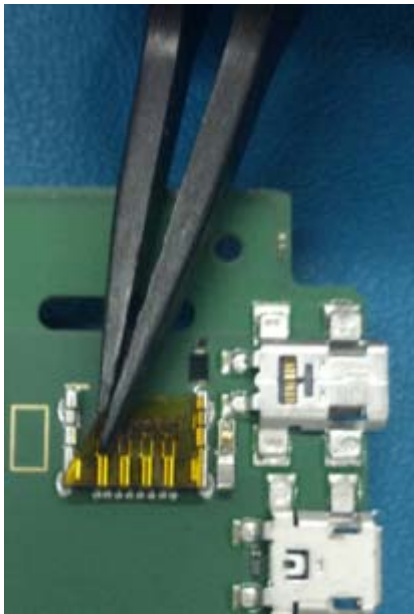
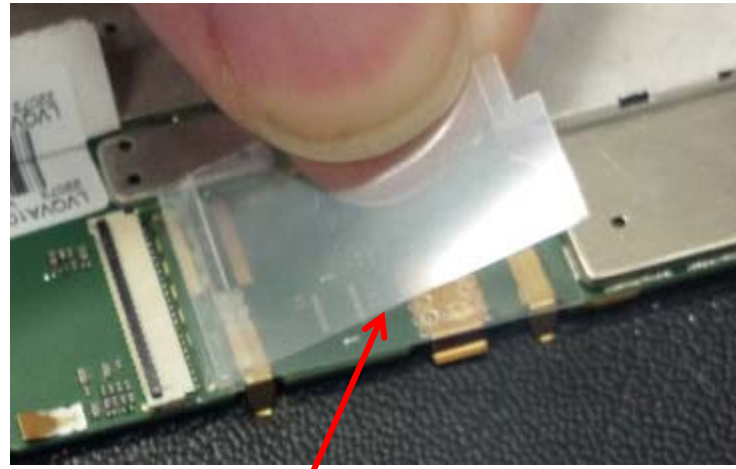
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Date

10/05/12

Page:
21

1. Place the Audio connector pad in front of the Audio ZIF connector
2. Place the Display Connector Mylar Tape in front of the display ZIF connector
3. Place 1 Kapton tape over the large welded spring contact near the shield
4. Remove protective tape from the Battery Receptacle



Symbols



Attention



Operation



Verification

Material List

Description / Part #	Qty
PCB	1
Audio Connector Pad	1
Mylar	1
Kapton	1

Tools/Equipment

Description	Parameters
Tweezers	NA

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Template Rev C



XT925

Assembly

HDMI/EMU Grommets
(topside / bottom side)

Global Doc #

Regional Doc #

Revision

1.1

Date

10/05/12

Page:

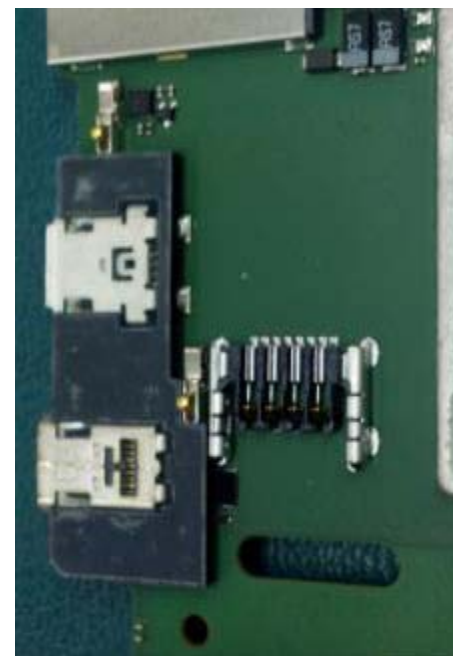
22



1. Place the Top Connector Grommet around the connectors on the populated side of the PCB



2. Place the SD Card Grommet around the SD Card Slot on the PCB as shown



Symbols



Attention



Operation



Verification

Material List

Description / Part #	Qty
PCB	1
Top Connector Grommet	1
SD Card Grommet	1

Tools/Equipment

Description	Parameters

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Template Rev C



XT925

Assembly

Secondary Mic Grommet

Global Doc #

Regional Doc #

Revision

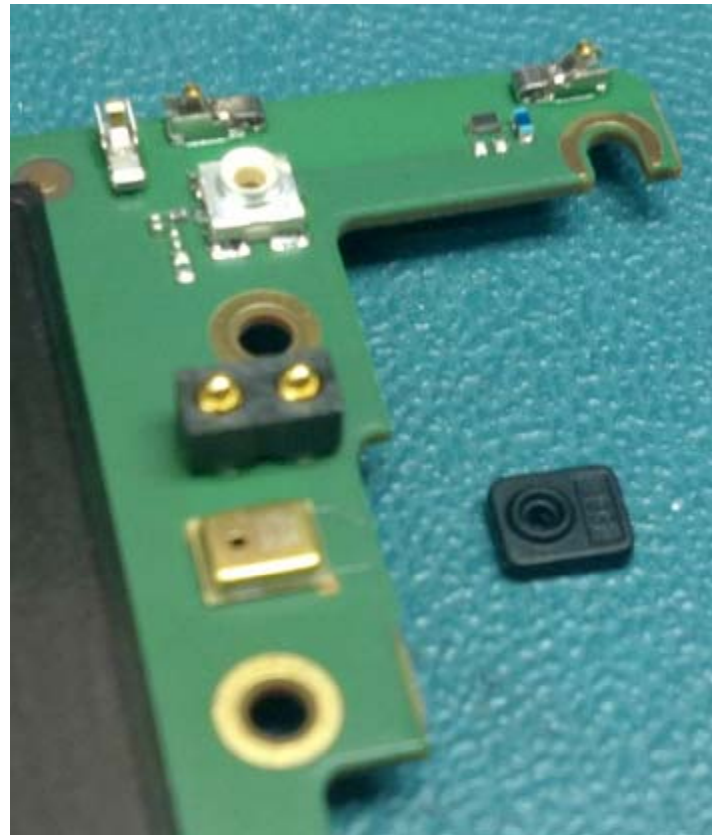
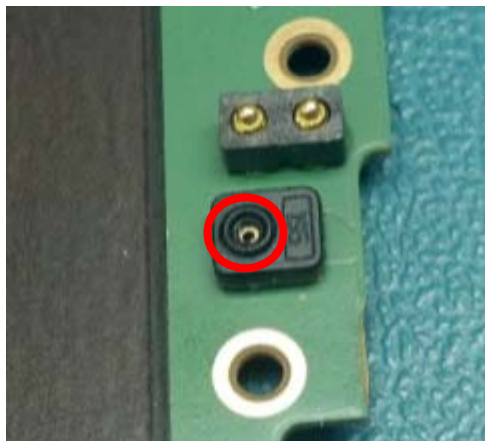
1.1

Date

10/05/12

Page:
23

1. Place the Secondary Mic Grommet over the port opening on the PCB Mic
2. Verify that the Grommet rests flush against the component and the port is visible



Symbols



Attention Operation Verification

Material List

Description / Part #	Qty
Rear Housing	1
Secondary Mic Grommet	1

Tools/Equipment

Description	Parameters



XT925

Assembly

Acoustic Gasket

Global Doc #

Regional Doc #

Revision

1.1

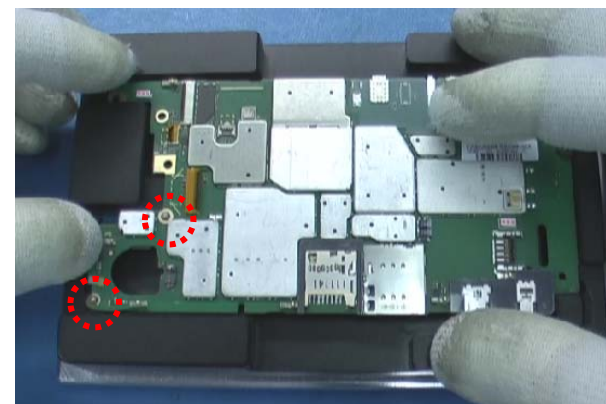
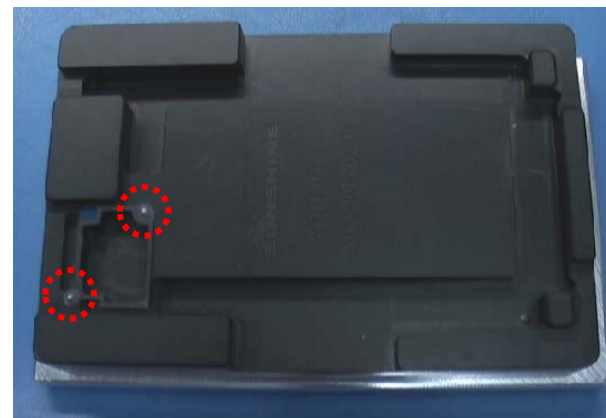
Date

10/05/12

Page:

24

-  1. Place the Acoustic Gasket in acoustic gasket alignment fixture by aligning to the fixture posts
-  2. Drop the PCB into acoustic gasket alignment fixture and apply light pressure to activate the adhesive
-  3. Remove the adhesive liner from the top of the Acoustic Gasket



Symbols



Attention



Operation



Verification

Material List

Description / Part #	Qty
PCB Sub-Assy	1
Acoustic Gasket	1

Tools/Equipment

Description	Parameters
Acoustic Gasket Alignment	NA

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Template Rev C



XT925

Assembly

SIM Door

Global Doc #

Regional Doc #

Revision

1.1

Date

10/05/12

Page:
25

Symbols



Attention Operation Verification

Material List

Description / Part #	Qty
PCB	1
Dummy SIM Tray	1

Tools/Equipment

Description	Parameters



1. Align the Dummy SIM Door Tray and assemble to the SIM card slot, sliding in until it stops



SAFETY CRITICAL

Inspect the PCB to ensure spring contacts are not bent inward where they could interfere, cut, or crush sides of the battery.



XT925

Assembly

PCB to Rear

Global Doc #

Regional Doc #

Revision

1.1

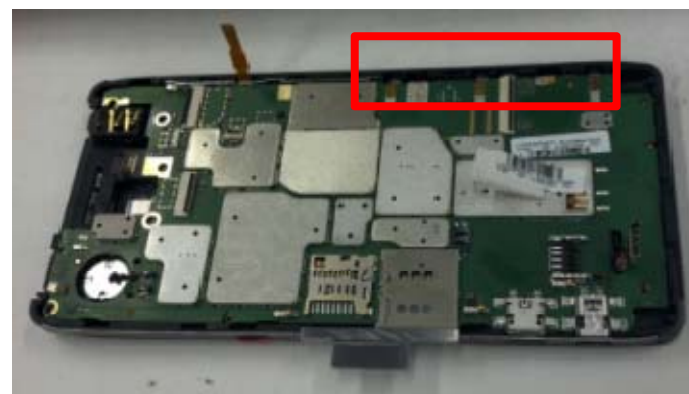
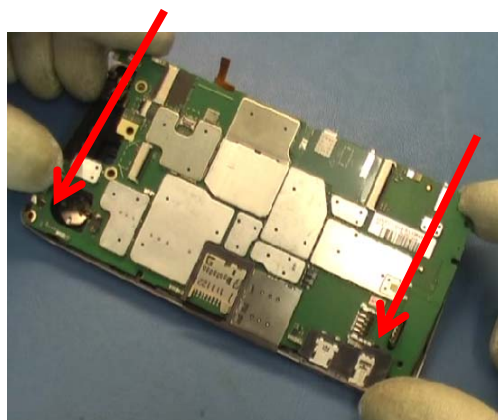
Date

10/05/12

Page:

26

1. Fold the Side Key Flex and FPR Flex clear of the PCB landing area
2. Lay the Rear Housing on a flat surface and route the Battery Flex through the slot in the PCB
3. Toe the PCB against the side wall of the rear housing being careful to align the connectors with the IO ports
4. After seating the PCB, pull lightly on the Battery Flex to pull the service loop through

**SAFETY CRITICAL**

1. Ensure surfaces around battery are free of foreign material
2. Align battery flex with PCB opening
3. Do not pinch battery or flex

Symbols

Attention



Operation



Verification

Material List

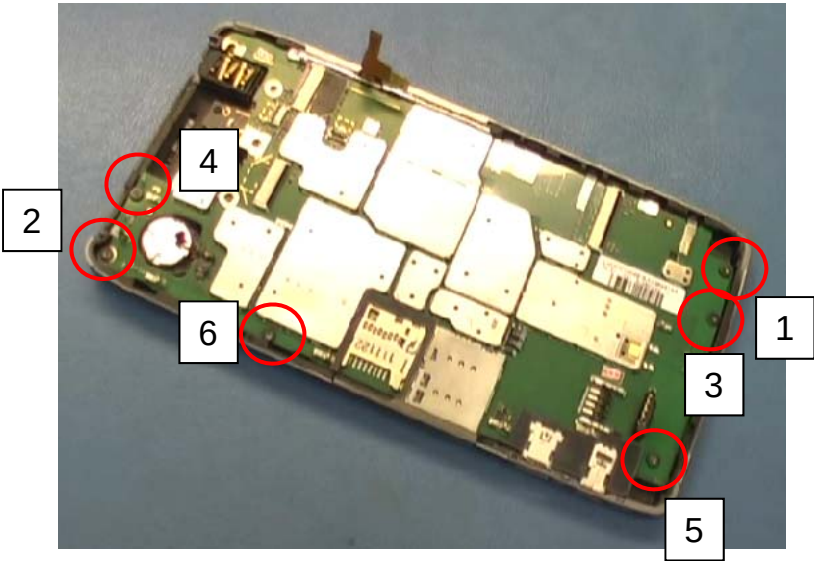
Description / Part #	Qty
Rear Housing Sub-Assy	1
PCB	1
Dummy SIM Tray	1

Tools/Equipment

Description	Parameters

1. Drive the 6x 5IP screws at 1.0 in-lbs to secure the PCB
-

▲ Follow the screw sequence shown



Symbols	
▲	Attention
■	Operation
●	Verification
Material List	
Description / Part #	Qty
XCVR Sub-Assy	1
PCB Screws	6
Tools/Equipment	
Description	Parameters
5IP Torque Driver	1.0 in-lbs



XT925

Assembly

Side Key Flex

Global Doc #

Regional Doc #

Revision

1.1

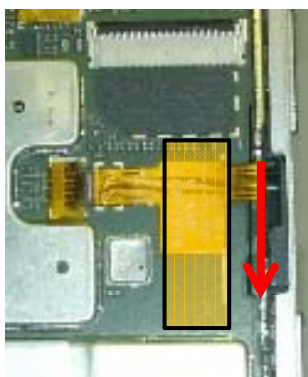
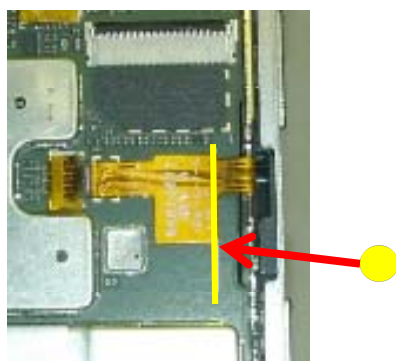
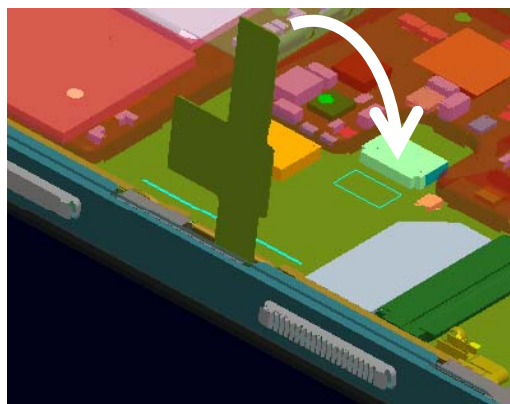
Date

10/05/12

Page:

28

1. Remove the Side Key adhesive liner and mate the ZIF connector for the Side Key Flex
2. Verify that the flex tail is pulled tight and the gold mark on the PCB is in line with the wing of the Side Key Flex
3. Wipe the flex inward towards the Connector to activate the adhesive
4. Place Kapton tape over the tail of the Side Key Flex to secure the position on the PCB



Symbols



Attention



Operation



Verification

Material List

Description / Part #	Qty
XCVR Sub-Assy	1
Audio ZIF Kapton Tape	1

Tools/Equipment

Description	Parameters

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Template Rev C



XT925

Assembly

Poly Speaker Cover

Global Doc #

Regional Doc #

Revision

1.1

Date

10/05/12

Page:
29

1. Connect the Poly speaker connector to the PCB
2. Place the Poly Speaker Cap to the PCB by aligning to the edge of the shield



3. Using the speaker to rear housing press, press the speaker for 5s



Symbols



Attention



Operation



Verification

Material List

Description / Part #	Qty
XCVR Sub-Assy	1
Poly Speaker Cap	1

Tools/Equipment

Description	Parameters
Speaker to rear housing Press	5s



XT925

Assembly

Main Imager

Global Doc #

Regional Doc #

Revision

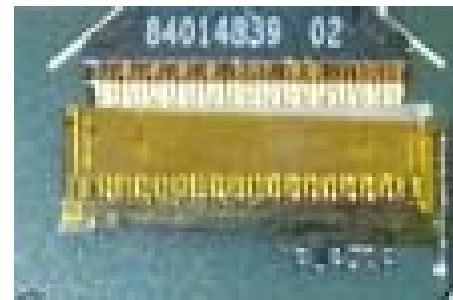
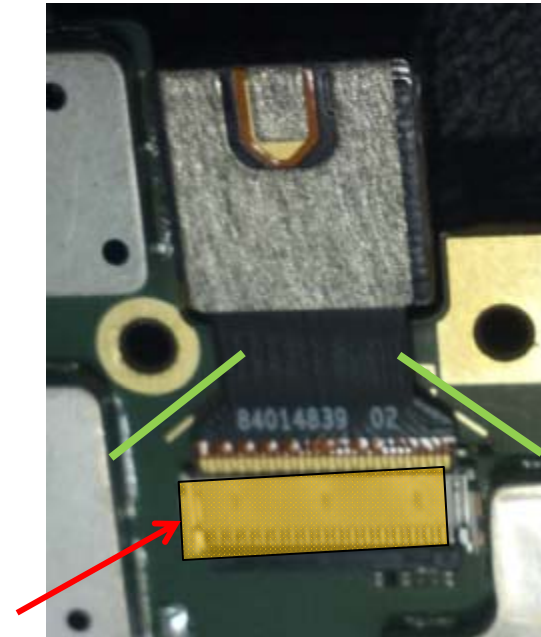
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Date

10/05/12

Page:
30

- 1. Clear the ZIF connector and Rear Housing Imager pocket with Ionized Air Gun to prepare for assembly
- 2. Mate the Main Imager Flex with the ZIF connection on the PCB as shown
● - Verify the Flex is fully inserted by inspecting the alignment marks on the PCB
- 3. Pull the Imager back to remove the protective liner and then return forward to drop the imager into the Rear Housing pocket
- 4. Place ZIF Kapton tape over the mated connection verify the door has been latched



Symbols



Attention



Operation



Verification

Material List

Description / Part #	Qty
XCVR Sub-Assy	1
Main Imager	1
Audio ZIF Kapton Tape	1

Tools/Equipment

Description	Parameters
Ionized Air Gun	
Tweezers	



XT925

Assembly

Main Imager Bracket

Global Doc #

Regional Doc #

Revision

1.1

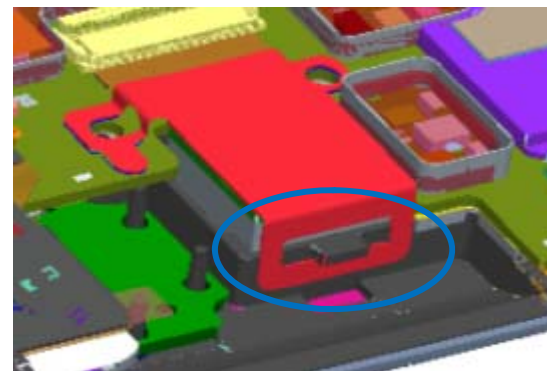
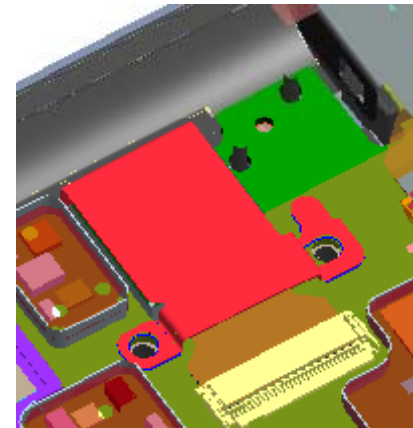
Date

10/05/12

Page:
31

1. Drop the Imager Bracket down over the Main Imager keeping the hook at the top and screw holes at the bottom

2. Hook the Imager Bracket to the top hook in the Rear Housing



Symbols



Attention



Operation



Verification

Material List

Description / Part #	Qty
XCVR Sub-Assy	1
Imager Bracket	1

Tools/Equipment

Description	Parameters



XT925

Assembly

Headset Jack Bracket

Global Doc #

Regional Doc #

Revision

1.1

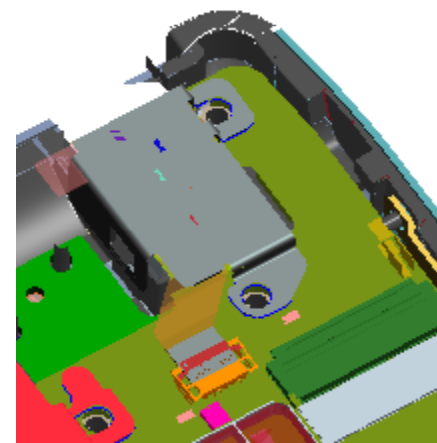
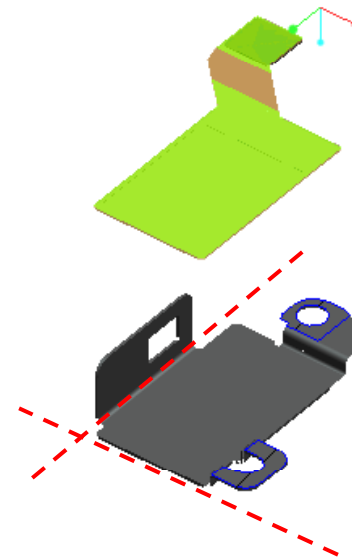
Date

10/05/12

Page:

32

1. Remove the adhesive liner and align the HSJ Flex to the highlighted edges of the HSJ Bracket
2. Mate the ZIF connector for the HSJ Flex
3. Lower the HSJ Bracket into the XCVR Sub-Assy, press down until the left hook snaps with the Rear Housing



Symbols



Attention



Operation



Verification

Material List

Description / Part #	Qty
XCVR Sub-Assy	1
HSJ Bracket	1
HSJ Flex	1

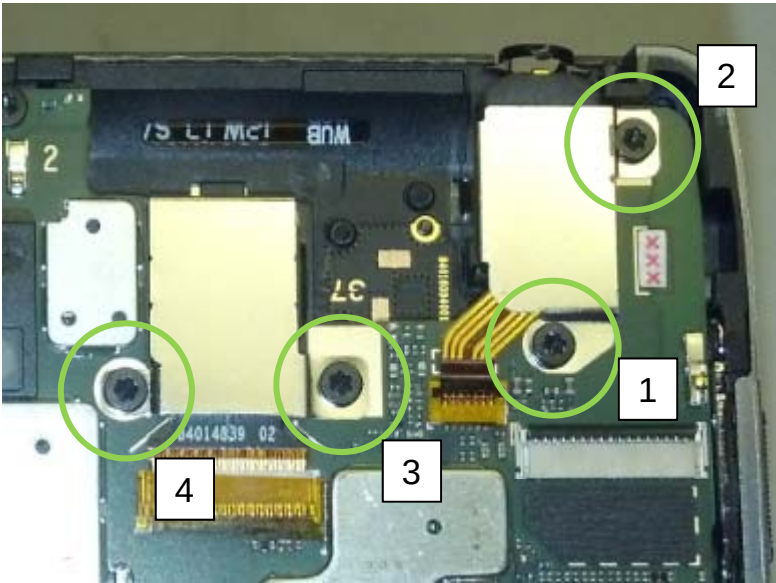
Tools/Equipment

Description	Parameters

1.

Drive 2x 5IP PCB Screws for the Main Imager Bracket at 1.0 in-lbs
2.

Drive 2x 5IP PCB Screws for the HSJ Bracket at 1.0 in-lbs



Symbols







Attention Operation Verification

Material List

Description / Part #	Qty
XCVR Sub-Assy	1
PCB Screws	4

Tools/Equipment

Description	Parameters
5IP Torque Driver	1.0 in-lbs



XT925

Assembly

Primary Mic Grommet

Global Doc #

Regional Doc #

Revision

1.1

Date

10/05/12

Page:

34

Symbols



Attention



Operation



Verification

Material List

Description / Part #	Qty
----------------------	-----

XCVR Sub-Assy	1
---------------	---

Primary Mic Grommet	1
---------------------	---

Tools/Equipment

Description	Parameters
-------------	------------

-  1. Assemble the Primary Mic Grommet to the PCB by aligning to the PCB screw head



-  2. Verify that the Mic Port is visible through the port opening





XT925

Assembly

ZIF Latch Kapton Tapes

Global Doc #

Regional Doc #

Revision

1.1

Date

10/05/12

Page:
35

1. Place Kapton tape over the Headset Jack ZIF connector when closed



2. Place Kapton tape over the side key flex ZIF connector when closed



Symbols



Attention



Operation



Verification

Material List

Description / Part #	Qty
XCVR Sub-Assy	1
Kapton	2

Tools/Equipment

Description	Parameters
Tweezers	NA



XT925

Assembly

Front Housing

Global Doc #

Regional Doc #

Revision

1.1

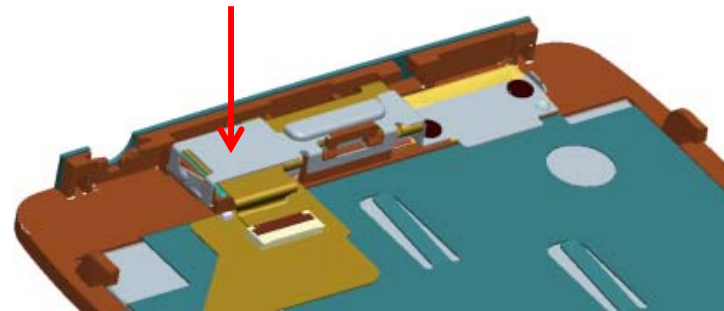
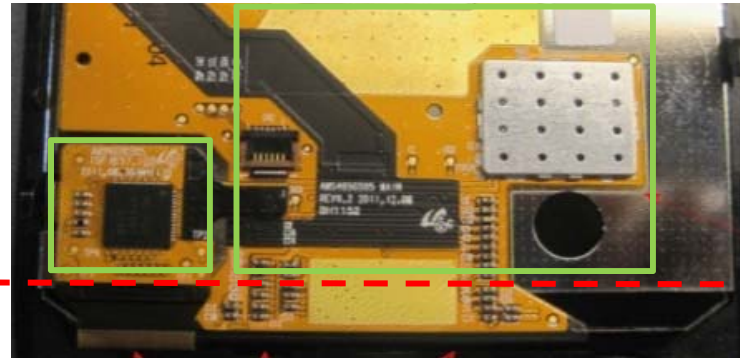
Date

10/05/12

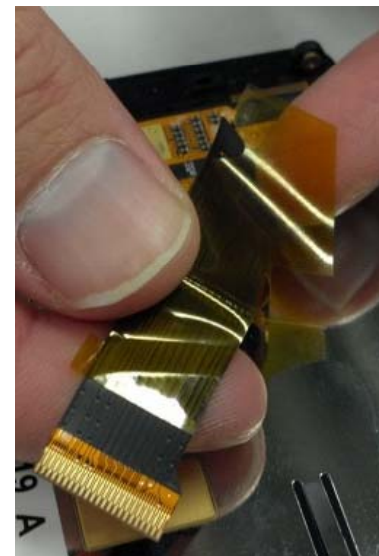
Page:

36

1. Before assembling the Front Housing, perform the following inspection:
- Check for any lift of the adhesive for the Display/ITO Flex; apply pressure to rewet if necessary
 - Pull back the liner and inspect the display glass for cracks
 - Check that the Front Housing Bracket is assembled



2. Remove the kapton tape from behind the Display Flex



Symbols



Attention



Operation



Verification

Material List

Description / Part #	Qty
Front Housing	1

Tools/Equipment

Description	Parameters

-
- At the XCVR Assembly station, place Customer IMEI Label on the Front Housing as shown (pocket in plastic)



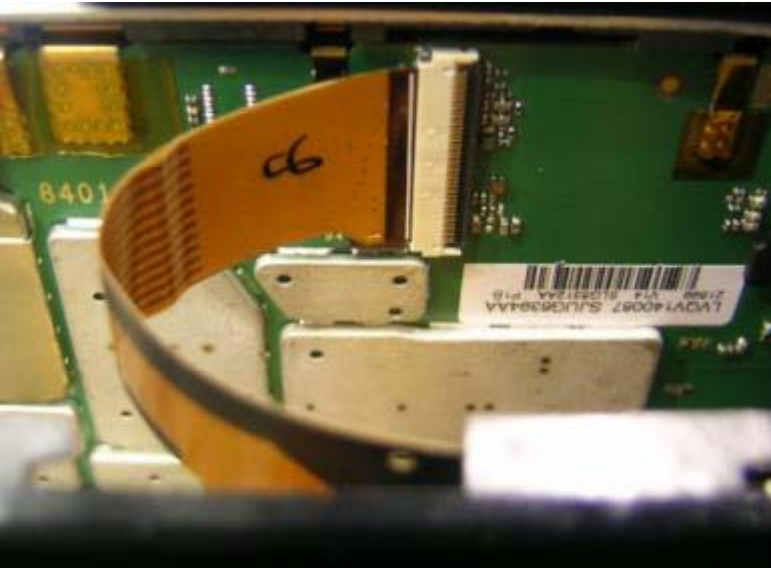
IMEI LABEL

Symbols	
	
Attention	Operation
	Verification
Material List	
Description / Part #	Qty
Front Housing	1
XCVR Assy	1
Pre-printed IMEI Label	1
Tools/Equipment	
Description	Parameters

1.

Flip the Display Flex 180degrees back and insert the flex until the white line is to the edge of the ZIF connector
2.

Close the ZIF Connector Latch Door



Symbols	
	
Attention	Operation
	Verification
Material List	
Description / Part #	Qty
XCVR Sub-Assy	1
Front Housing Sub-Assy	1
Tools/Equipment	
Description	Parameters



XT925

Assembly

Front Hsg to XCVR

Global Doc #

Regional Doc #

Revision

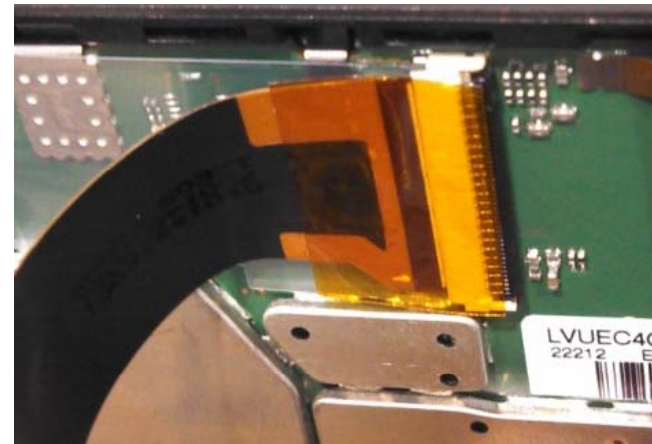
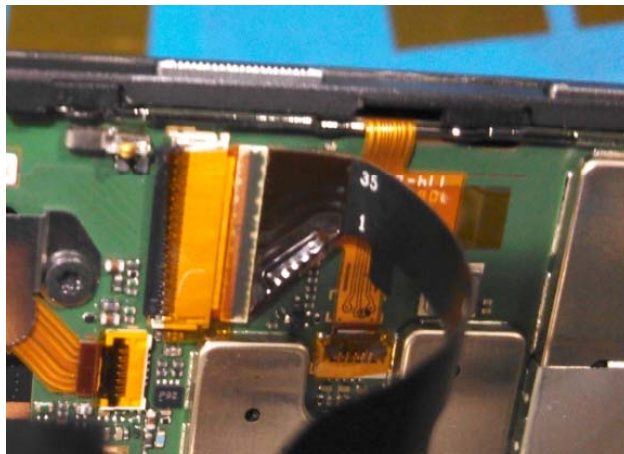
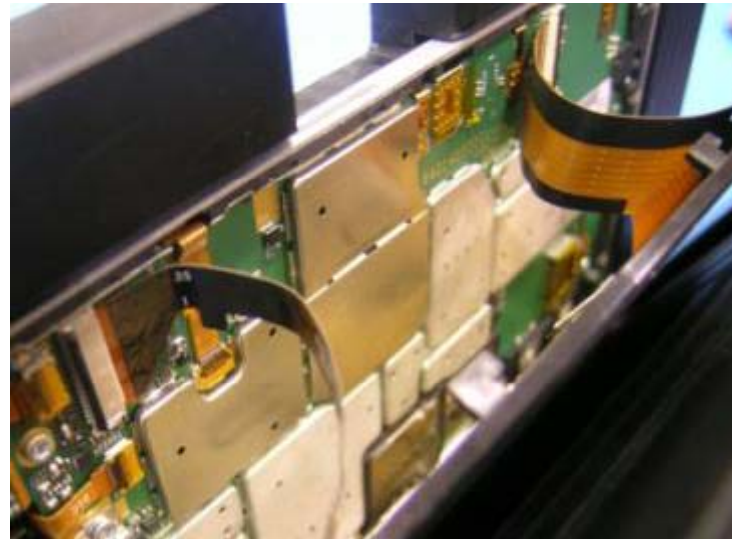
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Date

10/05/12

Page:
39

1. Flip the Audio Flex 180degrees back and insert the flex until the white line is to the edge of the ZIF connector
2. Close the ZIF Connector Latch Door
3. Place Kapton tape over the Audio ZIF Connector to verify that the flex is fully inserted and the latch door has been closed
4. Place Kapton tape over the Display ZIF Flex and Connector to verify that the flex is fully inserted, the latch door has been closed, and the flex will not back out



Symbols



Attention Operation Verification

Material List

Description / Part #	Qty
XCVR Sub-Assy	1
Front Housing Sub-Assy	1
Audio ZIF Kapton Tape	1
Display ZIF Kapton Tape	1

Tools/Equipment

Description	Parameters

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Template Rev C



XT925

Assembly

Battery Connection

Global Doc #

Regional Doc #

Revision

1.1

Date

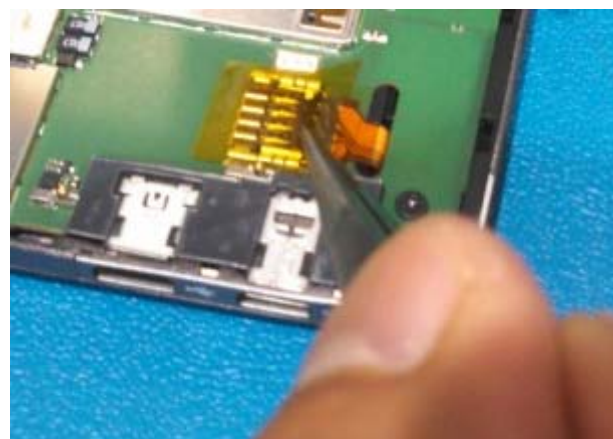
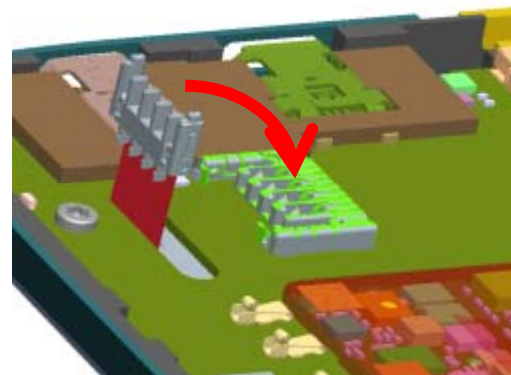
10/05/12

Page:

40



1. Mate the Battery Flex Connector to the PCB by toeing in the top of the connector and snapping down



Symbols



Attention



Operation



Verification

Material List

Description / Part #

Qty

Rear Housing Sub-Assy

1

Tools/Equipment

Description

Parameters

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Template Rev C



XT925

Assembly

Hook & Slide

Global Doc #

Regional Doc #

Revision

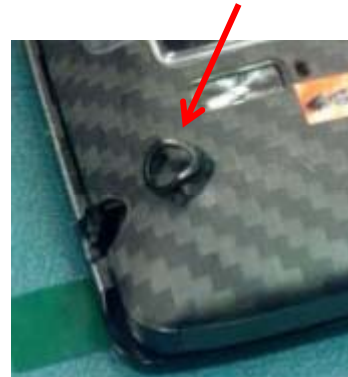
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Date

10/05/12

Page:
41

1. With the Front Housing shifted slightly above the XCVR Side, drop the side hook features into the open pockets
2. Check the perimeter to verify the Front Housing is seated against the XCVRs Rear Housing,
3. Place the Front Housing down on the bench applying light pressure on the Rear Housing
4. Drop the HSJ Bezel onto the Rear Housing and align it to the opening
5. Holding the Front Housing in place on the bench, apply light pressure down on the Rear Housing, and slide the Rear Housing into assembled position
6. The final assembly should appear flush around the perimeter



Symbols



Attention Operation Verification

Material List

Description / Part #	Qty
XCVR Sub-Assy	1
HSJ Bezel Ring	1

Tools/Equipment

Description	Parameters



XT925

Assembly

Rear Base Screws

Global Doc #

Regional Doc #

Revision

1.1

Date

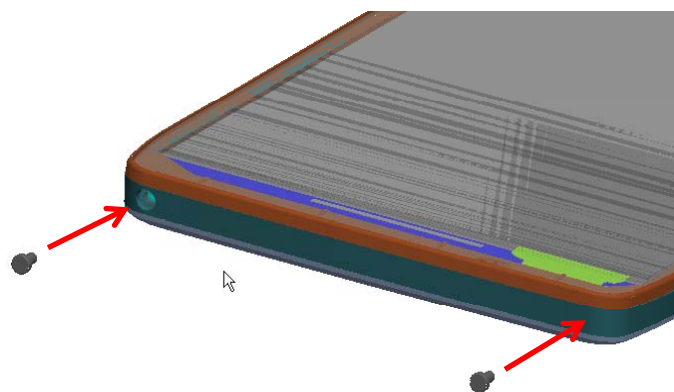
10/05/12

Page:

42



1. Drive 2x 5IP Base Screws at 1.1 in-lbs



Symbols



Attention



Operation



Verification

Material List

Description / Part #	Qty
Vanquish Assy	1
Base Screws	2

Tools/Equipment

Description	Parameters
5IP Torque Driver	1.1 in-lbs

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